

Ship July 6th or sooner

Work Order ID 60000



Page 1

June 22, 2010 2:33:17 PM

Item ID: D205-541-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D205-541

J

D4041

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD205-541-141

CHG001

8/10/07/06

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble basket as per Dwg.

8/10/07/06 @

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Item ID: D205-541-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/07/06

Memo

0.00

⑩

130



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

8/10/07/23

①

140



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

8/10/07/06

Memo

0.00

⑩

Work Order ID 60000

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Item ID: D205-541-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-541-141

Location:

PPP Rev: *ARPT*

6/27/10 ①

160



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

MF
10-7-6

Picklist Print

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH



Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.02.11 verified by:JLM
per ecn10-550 DD verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4042-041 		Manufactured	No			110	Each	0.0000	1	1		6/30/07/05	
Short Basket Base Assembly, LH													
D4047-041 		Manufactured	No			110	Each	0.0000	1	1		6/30/07/05	
Short Basket Lid Assembly													
D2530 		Manufactured	No			110	Each	0.0000	1	1		6/30/07/05	
Handle Weldment													
D2535 		Manufactured	No			110	Each	114.0000	2	2		6/30/07/05	
Spring													

Location	Loc Qty	Loc Code
ST504	114	
56355	14	
58331	100	

D4053-1 		Manufactured	No			110	Each	8.0000	1	1		6/30/07/05	
Placard													

Location	Loc Qty	Loc Code
ENG	8	
55278	8	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 60000

Parent Item: D205-541-141


Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No 110 Each 11.0000 1

 Spring (Basket Lid)

Location

Loc Qty


Loc Code

ST 11
 56386 1
 58986 10



1 ~

[Handwritten signature]

D2537 Manufactured No 110 Each 15.0000 2

 Bushing

Location

Loc Qty

Loc Code


ST504 15
 58429 15



2

SF986

[Handwritten signature]

D3953-3 Manufactured No 110 Each 26.0000 2

 Gas Spring Stud, Lid

Location

Loc Qty

Loc Code


ST102 26
 58894 6
 59437 20



2

SF929

[Handwritten signature]

D3953-7 Manufactured No 110 Each 26.0000 2

 Spring Spacer

Location

Loc Qty

Loc Code

ST103 26
 58893 6
 59438 20



2

SF894

[Handwritten signature] 6/14/10 23 ①

SF893

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

110

Each

20.0000

2

2



Gas Spring Washer

Location

Loc Qty

Loc Code

ST101

20

53642

2

59147

18

D3953-17 Manufactured No

110

Each

32.0000

2

2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST101

32

57143

1

58857

1

59197

30

D3953-19 Manufactured No

110

Each

15.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST101

1

57607

1

ST103

14

D3953-21 Manufactured No

110

Each

26.0000

1

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

21

57145

4

59214

17

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3917-3
Washer

Manufactured No

110 Each

25.0000

6 6 ~

Location

Loc Qty

Loc Code

ST096

25

57144

1

58892

24

AN310-4
NUT

Purchased No

110 Each

15.0000

5 5 ~

Location

Loc Qty

Loc Code

ST324

12

114716

12

ST349

3

114341

3

AN3-14A
Bolt

Purchased No

110 Each

80.0000

4 4 ~

Location

Loc Qty

Loc Code

ST351

80

114330

30

114941

50

AN3-16A
Bolt

Purchased No

110 Each

141.0000

2 2 ~

Location

Loc Qty

Loc Code

ST352

141

113845

21

114523

20

114752

100

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No 110 Each 58.0000 3 3

Location	Loc Qty	Loc Code
ST357	58	
114292	8	
114784	50	

AN5-17A Purchased No 110 Each 143.0000 4 4

Location	Loc Qty	Loc Code
ST339	143	
114330	97	
114784	46	

MS21042L3 Purchased No 110 Each 3,067.000 6 6

Location	Loc Qty	Loc Code
ST300	3067	
114523	567	
114718	500	
114784	2000	

MS21042L5 Purchased No 110 Each 677.0000 4 4

Location	Loc Qty	Loc Code
ST139	500	
114813	500	
ST300	177	
114449	177	

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

MS 24665-151

10.07.06
PER 051042

MS24665-231



cotter pin

Purchased

No

110

Each

176.0000

5

Start Date: 6/22/10

Start Qty: 1.00

Required Date: 7/05/10

Required Qty: 1.00

Location

Loc Qty

Loc Code

ST331

176

113815

176

NAS1149F035P

Purchased

No

110

Each

173.0000

4



Washer

Location

Loc Qty

Loc Code

ST275

173

113254

73

114382

100

NAS1149F0463P

Purchased

No

110

Each

141.0000

5



Washer

Location

Loc Qty

Loc Code

ST275

141

114223

41

114348

100

NAS1149F0563P

Purchased

No

110

Each

220.0000

4



Washer

Location

Loc Qty

Loc Code

ST275

20

108471

20

ST298

200

114576

200

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.07.06	110	MS24665-231 IS TOO BIG IN Ø AND TOO LONG. CHANGE TO MS24665-151 WHICH IS OF ADEQUATE SIZE AND LENGTH. PERMANENT CHG. M 17566	EB	10/07/06	B	10.07.06 EBWAL		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

DSI 9302-011

Manufactured No

(130 Each

1.0000



Strut Modification

CHC701



B60039

60

Location

Loc Qty

Loc Code

FG

1

58276

1

D2022-101

Manufactured No

130 Each

189.0000



Spacer



2

2

60

Location

Loc Qty

Loc Code

ST504

189

50746

89

52325

100

D2332-041

Manufactured No

130 Each

2.0000



Lid Prop Assembly 6.69" long



1

60

Location

Loc Qty

Loc Code

ST512

2

57645

2

D2464

Manufactured No

130 f

330.6534

3.4166



3/4 Seal



57645

3.4166

3.42

60/01

Location

Loc Qty

Loc Code

ST402

330.6534

48173

330.6534

(D2464-0410) cut (1) at 41.00"

48173

June 22, 2010 2:32:53 PM

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No 130 Each 20.0000



Gas Spring Washer

2 2



Location Loc Qty Loc Code

ST101 20

53642 2

59147 18

D4048-041 Manufactured No 130 Each 0.0000



Mounting Lug Assembly, LH



59147

360001

D4048-5 Manufactured No 130 Each 1.0000



Mounting Lug



Location Loc Qty Loc Code

ST460 1

58067 1

D4048-7 Manufactured No 130 Each 1.0000



Mounting Lug



58067

Location Loc Qty Loc Code

ST111 1

58069 1

D4048-9 Manufactured No 130 Each 32.0000



Bushing



58069

19

Location Loc Qty Loc Code

ST111 32

58071 32

58071

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D4049-041

Manufactured No

130

Each

1.0000



Mounting Lug Assembly, LH

Location

Loc Qty

Loc Code

ST

1

58072

1

D4049-5

Manufactured No

130

Each

3.0000



Mounting Lug, LH

Location

Loc Qty

Loc Code

ST111

3

58081

3

D4050-1

Manufactured No

130

Each

1.0000



Strut

Location

Loc Qty

Loc Code

ST254

1

56409

1

D4050-3

Manufactured No

130

Each

1.0000



Strut

Location

Loc Qty

Loc Code

ST254

1

46451

1

D4050-5

Manufactured No

130

Each

1.0000



Strut

Location

Loc Qty

Loc Code

ST267

1

58083

1

June 22, 2010 2:33:00 PM

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 60000

Parent Item: D205-541-141






Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D4051-041  Rappel Deflector Assembly, LH D4052-1  Eye Bolt	Manufactured	No	130	Each	0.0000	 11 BS9999	
	Manufactured	No	130	Each	8.0000	 12	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN4-6A
Bolt

Purchased No 130 Each 1,121.000

Location	Loc Qty	Loc Code
ST356	1121	
112933	96	
113149	522	
114523	2	
114615	1	
114941	500	

M113149

AN4-7A
Bolt

Purchased No 130 Each 194.0000

Location	Loc Qty	Loc Code
ST356	194	
113226	194	

M113236

AN4-12A
Bolt

Purchased No 130 Each 226.0000

Location	Loc Qty	Loc Code
ST357	226	
112314	226	

M112314

AN4-14A
Bolt

Purchased No 130 Each 312.0000

Location	Loc Qty	Loc Code
ST357	296	
114752	296	
ST358	16	
113359	16	

M114752

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN4-16A Purchased No

130

Each

60.0000



Bolt

Location

Loc Qty

Loc Code

ST358

60

114523

60

AN960-10 NAS1149F0363P Purchased No

130

Each

8,012.000



Washer

Location

Loc Qty

Loc Code

ST348

8012

19356

200

5519

7812

AN960-416 NAS1149F0463P Purchased No

130

Each

0.0000



Washer

AN960JD10L NAS1149D0332J Purchased No

130

Each

3,625.000



Washer

Location

Loc Qty

Loc Code

ST348

3625

110985

3625

AN960JD416 NAS1149D0463J Purchased No

130

Each

6.0000



Washer

Location

Loc Qty

Loc Code

ST357

6

107939

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased No
Washer

130 Each 307.0000

Location

Loc Qty

Loc Code

ST346

307

110153

307

MS21042L3 Purchased No
Nut

130 Each 3,067.000

Location

Loc Qty

Loc Code

ST300

3067

114523

567

114718

500

114784

2000

MS21042L4 Purchased No
Nut

130 Each 3,026.000

Location

Loc Qty

Loc Code

ST300

3026

113422

68

114523

28

114718

930

114784

2000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/24/16	#100	Per. <i>[Signature]</i> P. + Q. To MS21042+3 Should be 13 not 6. ADD copy of BOM for Ref. Was correct <i>[Signature]</i> 10.02.06					<i>[Signature]</i> 10/27/16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 22, 2010 2:33:11 PM

Page 14 114

Work Order ID: 60000

Parent Item: D205-541-141

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

130

Each

1,360.000

2

2

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1320

112492

25

113069

8

114348

487

114523

500

114784

300

1114398

June 22, 2010 2:33:11 PM

Shop Packet Print

Page 14

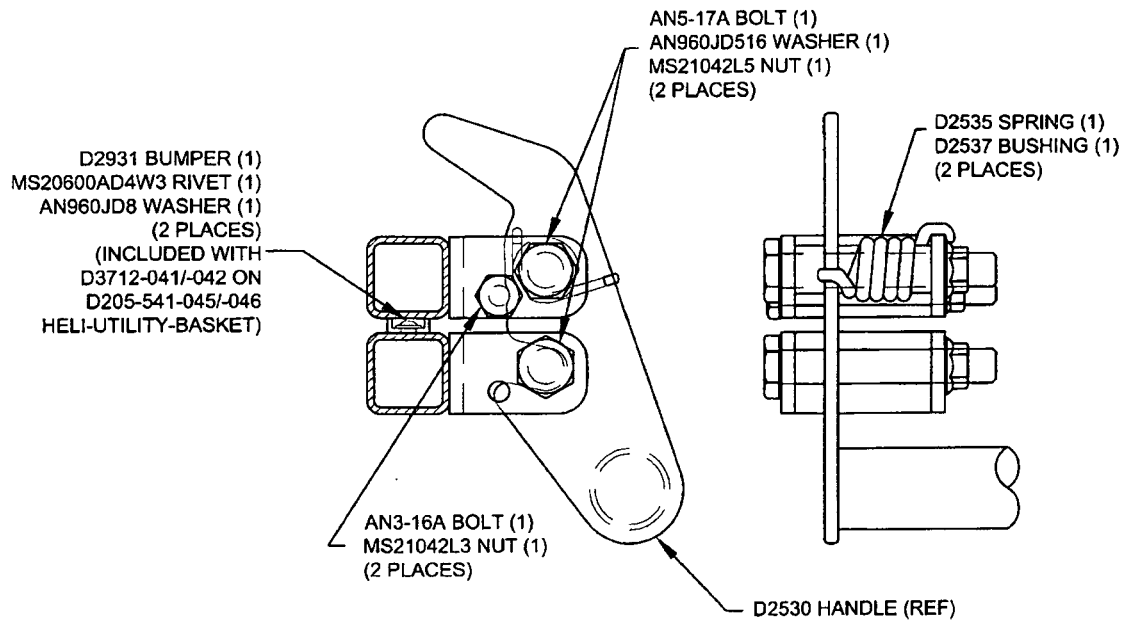


Figure 25-9 – Detail 'H' Handle Assembly

who
60000

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25-00-00

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Resolution _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

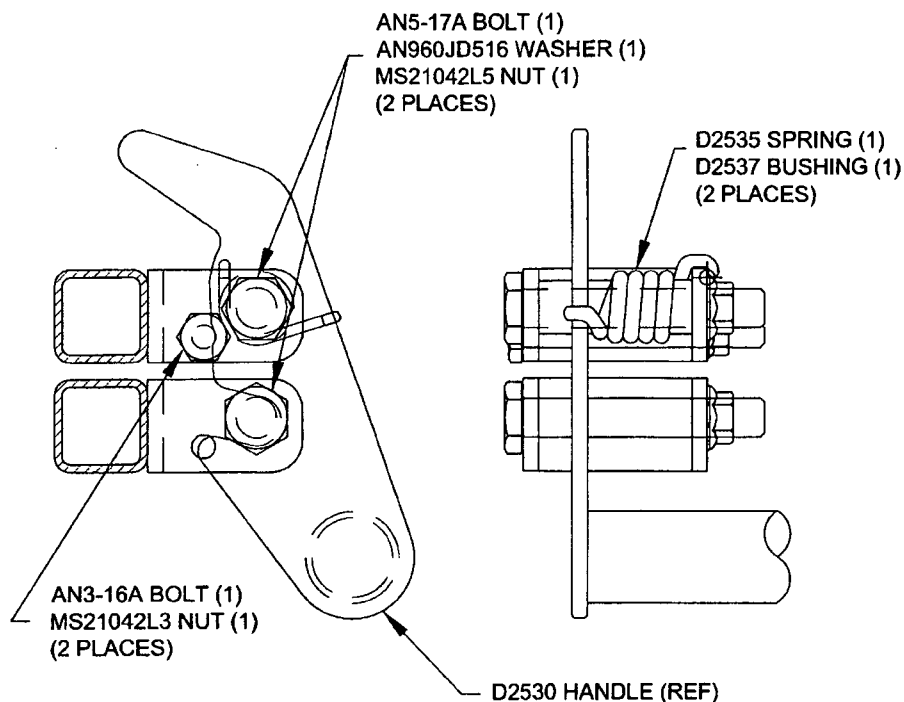


Figure 9 - Detail 'H' Handle Assembly

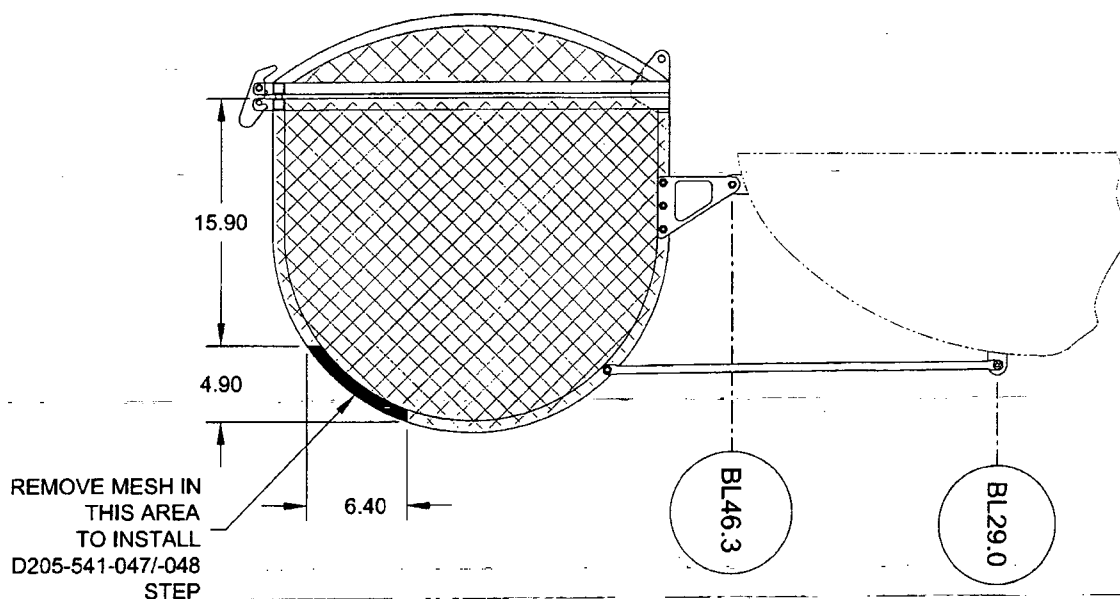


Figure 10 - Mesh Removal Looking Aft at STA 84.00
(D205-541-044 Shown; D205-541-043 Opposite)

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

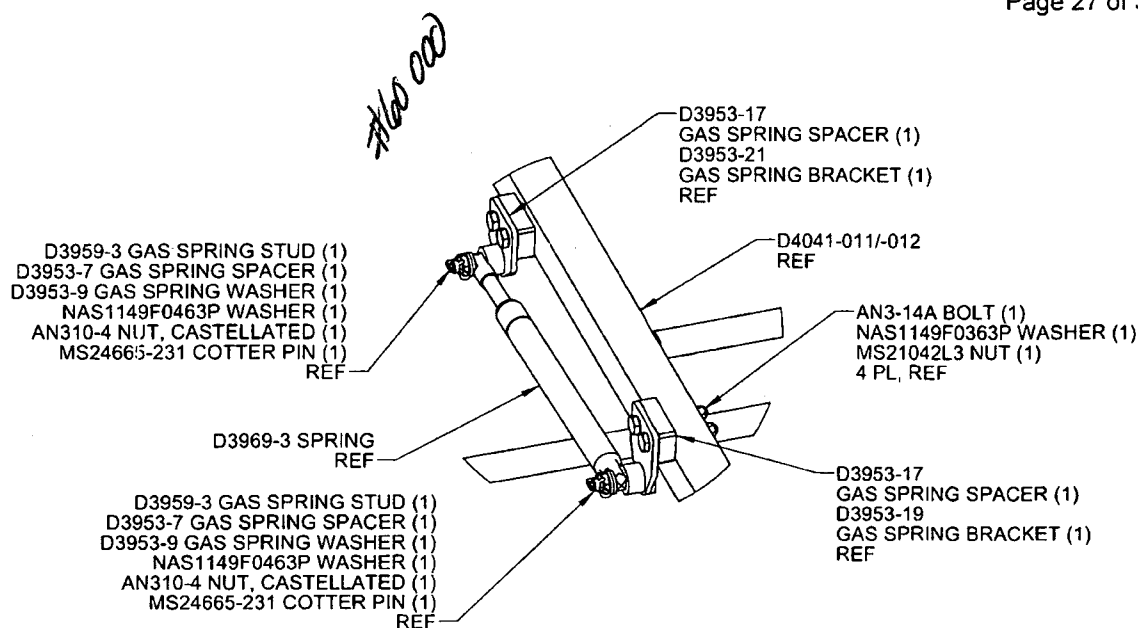


Figure 20 – Gas Spring Installation at STA 193.0
(D205-541-141 Shown; D205-541-142 Opposite)
(Mesh not Shown for Clarity)

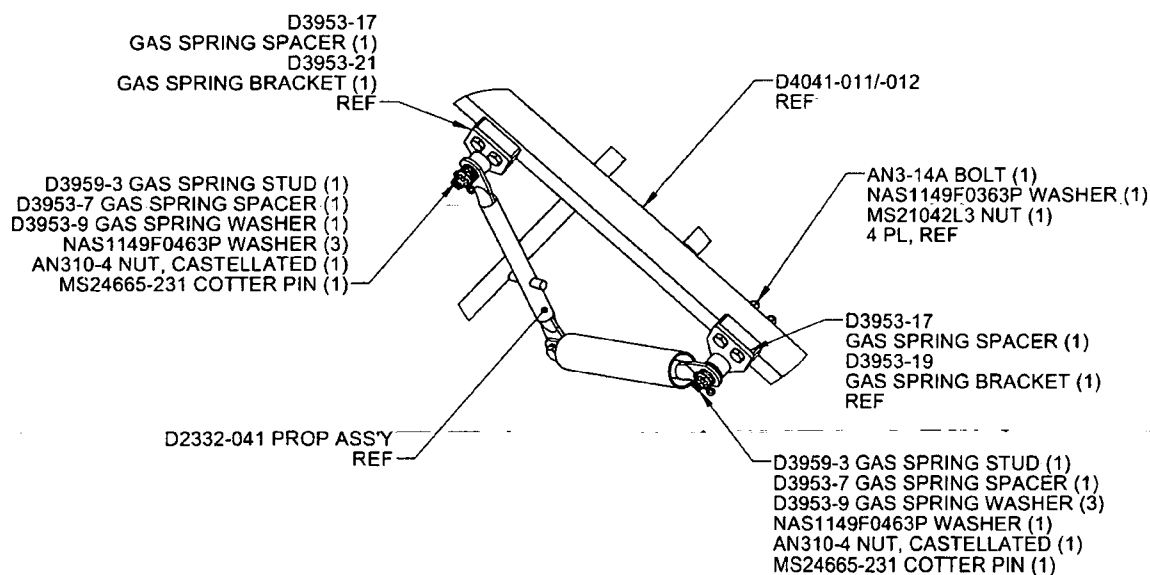


Figure 21 – Prop Arm Optional Installation at STA 193.0
(D205-541-141 Shown; D205-541-142 Opposite)
(Mesh not Shown for Clarity)

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

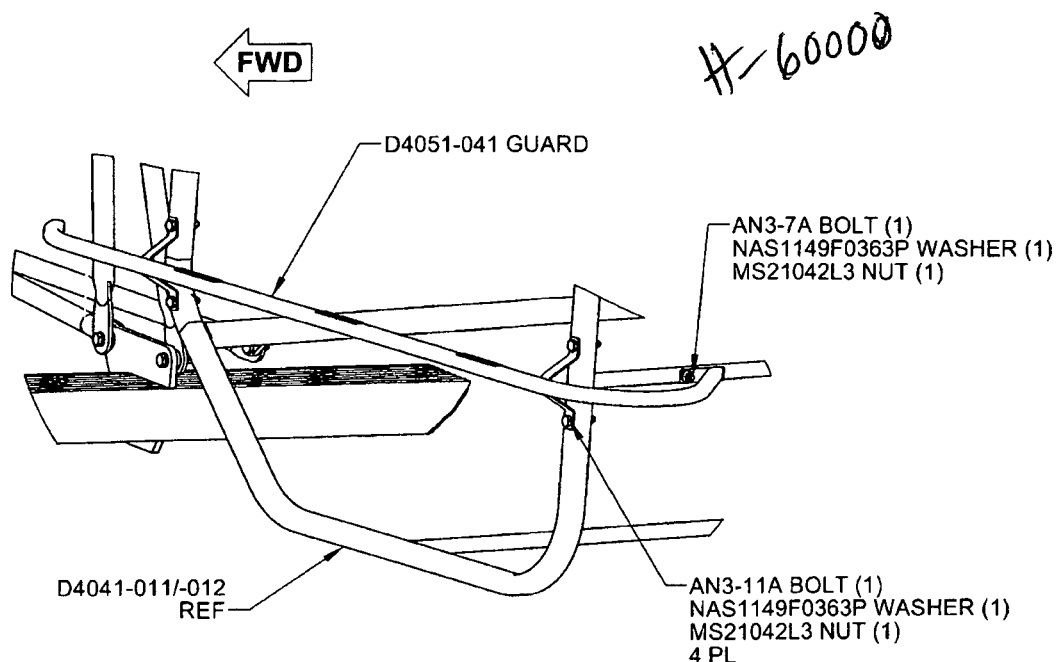


Figure 22 – Guard Installation at STA 129.0

(D205-541-141 Shown; D205-541-142 Opposite)

(Mesh not Shown for Clarity)

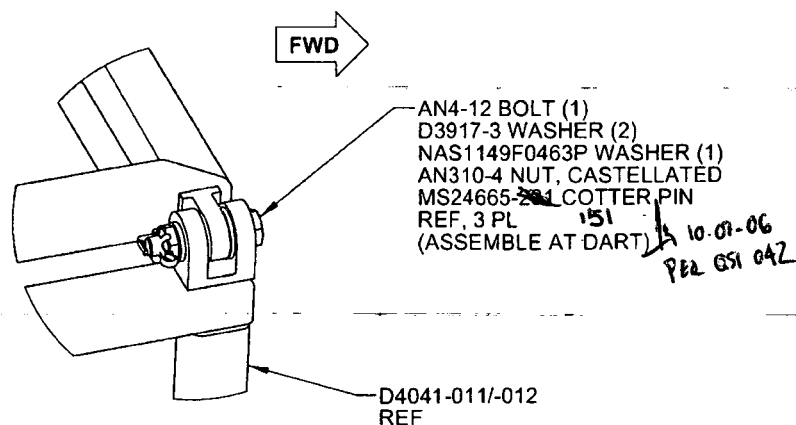


Figure 23 – Hinge Detail

(D205-541-141 Shown; D205-541-142 Opposite)

(Mesh not Shown for Clarity)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 76.11 in - 1.93 m	- 1066 in-lb - 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 76.11 in + 1.93 m	+ 1066 in-lb + 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-141 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	- 59.9 in - 1.5 m	- 4133 in-lb - 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg
D205-541-142 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	+ 59.9 in + 1.5 m	+ 4133 in-lb + 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
X						D205-541-043	HELI-UTILITY-BASKET, LH
	X					D205-541-044	HELI-UTILITY-BASKET, RH
		X				D205-541-045	HELI-UTILITY-BASKET, LH
			X			D205-541-046	HELI-UTILITY-BASKET, RH
				X		D205-541-141	HELI-UTILITY-BASKET, LH
					X	D205-541-142	HELI-UTILITY-BASKET, RH
					1	DSI 9302-011	STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION)
2*	2*					D2022-101	SPACER
				2	2	D2022-101	SPACER (FOR D205-633 STEP INSTALLATION)
1	1	1	1			D2199-1	STRUT
1	1	1	1			D2199-23	STRUT
1	1	1	1			D2199-25	STRUT
1*	1*	1*	1*			D2258-300	LABEL
1*	1*	1*	1*			D2332-041	PROP ASSEMBLY
				1	1	D2332-041	PROP ASSEMBLY (OPTIONAL)
				1	1	D2464-0410	NEOPRENE SEAL
1	1	1	1			D2498	MOUNTING LUG
1	1	1	1			D2499	MOUNTING LUG
1*	1*					D2512	BASKET LID ASSEMBLY

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
2	2	2	2			D2515	BUSHING
1*	1*	1*	1*			D2530	HANDLE ASSEMBLY
2*	2*	2*	2*			D2535	SPRING
2*	2*	2*	2*			D2537	BUSHING
2*	2*					D2931	BUMPER
1	1	1	1			D3052-1	MOUNTING LUG
1*						D3053-041	BASKET BASE ASSEMBLY, LH
	1*					D3053-042	BASKET BASE ASSEMBLY, RH
		1*				D3712-041	BASKET BASE
			1*			D3712-042	BASKET BASE
		1*				D3713-041	LID ASSEMBLY
			1*			D3713-042	LID ASSEMBLY
		6*	6*			D3723-1	BUSHING
				2	2	D3953-9	GAS SPRING SPACER (OPTIONAL)
				1		D4041-011	SHORT BASKET ASS'Y, LH
					1	D4041-012	SHORT BASKET ASS'Y, RH
				1		D4048-041	MOUNTING LUG ASS'Y
					1	D4048-042	MOUNTING LUG ASS'Y
				1		D4048-5	MOUNTING LUG
					1	D4048-6	MOUNTING LUG
				1		D4048-7	MOUNTING LUG
					1	D4048-8	MOUNTING LUG
				6	6	D4048-9	BUSHING
				1		D4049-041	MOUNTING LUG ASS'Y
					1	D4049-042	MOUNTING LUG ASS'Y
				1		D4049-5	MOUNTING LUG
					1	D4049-8	MOUNTING LUG
				1	1	D4050-1	STRUT
				1	1	D4050-3	STRUT
				1		D4050-5	STRUT
					1	D4050-8	STRUT
				1		D4051-041	GUARD (OPTIONAL)
					1	D4051-042	GUARD (OPTIONAL)
				2	2	D4052-1	EYE BOLT
				10	10	AN3-5A	BOLT
				1	1	AN3-7A	BOLT (OPTIONAL)
				4	4	AN3-11A	BOLT (OPTIONAL)
2*	2*	2*	2*			AN3-16A	BOLT
				5	5	AN4-6A	BOLT
2*	2*					AN4-7A	BOLT
2	2	2	2	1	1	AN4-7A	BOLT
3	3	3	3	2	2	AN4-12A	BOLT
9	9	9	9			AN4-13A	BOLT
2	2	2	2	11	11	AN4-14A	BOLT
				1	1	AN4-16A	BOLT
		3*	3*			AN4-20A	BOLT

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Ship July 6th or sooner

Work Order ID 60000

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Page 1

Item ID: D205-541-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D205-541

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CHG001

110-6-23

REFERENCE ONLY

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0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble basket as per Dwg.